

Date: Monday, 05/05/2008 11:11:52 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 39033		
Estimate Number	: 13292		
P.O. Number	:	Part Number	: D37853
This Issue	: 05/05/2008 S.O. No. :	Drawing Number	: D3785 PRELIM
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : R & D SM/MED FAB	Drawing Revision	: PRELIM 08.05.22
Previous Run	:	Material	:
Written By	:	Due Date	: 08/05/2008 Qty: 3 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A 08-05-01 new issue DD. verified by:EC		

Additional Product

FOR ENGINEERING USE ONLY

~~PRELIMINARY ISSUE~~

Job Number:



PROTOTYPE

Seq. #: Machine Or Operation: Description:

1.0 M304S11GA 176061 T6 5080 304/316 .125 Sheet



Comment: Qty.: 0.2356 sf(s)/Unit Total: 0.2356 sf(s)

304/316 .125 Sheet 6061-T6 0.80" Sheet

Batch: 104934 HB 8-5-5

HB 8-5-22

107904

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3785

Dwg Rev: PRE-L.

Prog Rev: PRE-L.

HB 8-5-5

HB 8-5-22

(2)

2- Debur if necessary

HB 8-5-5

HB 8-5-22

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



HB 8-5-5

HB 8-5-22



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

S 08/05/05 (2)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3785

HB 08/05/13 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 3785-3 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR: <u>39033</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/05/21</u>		Scrap due to material chg S.S. to Alum 6061 T6	<u>[Signature]</u>	Scrap and destroy all parts <u>Redue with new material Chg</u>	<u>[Signature]</u> <u>08/05/21</u>	<u>[Signature]</u> <u>0805-22</u>	<u>[Signature]</u> <u>0805-22</u>	<u>[Signature]</u> <u>0805-22</u>
				Replace on this W/O Qty 1 M <u>107904</u>				

NOTE: Date & initial all entries

Date: Monday, 05/05/2008 11:11:52 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 39033

Part Number: D37853

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/05/13 (15)

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-counter sink holes as per dwg D3785

FP 08-05-22 X2
ml 08/05/14 (2)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ENGINEERING
APPROVAL
S 08/05/14 (2)

08.05.14 (2)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location:

Quarantine

FOR ENGINEERING USE ONLY

08/05/26 (2)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/27
08.06.04 Perotype
MF 08-05-27

Job Completion



00224A

POSITIVE RECALL

EFFECTIVE

RELEASED

AUTH

DATE

08.05.27

Dart Aerospace Ltd

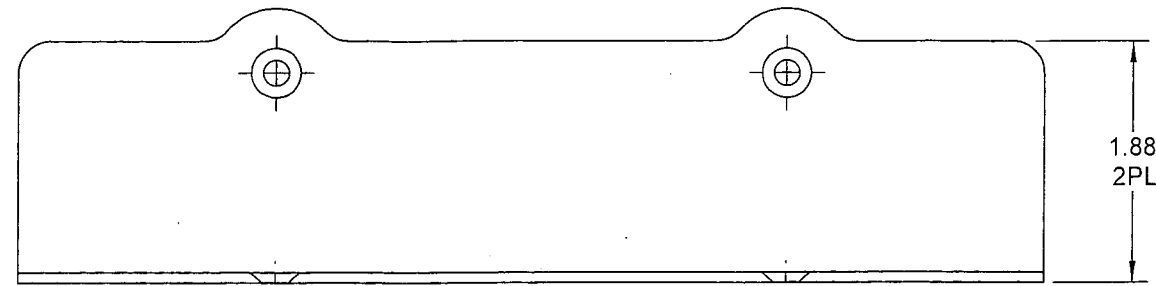
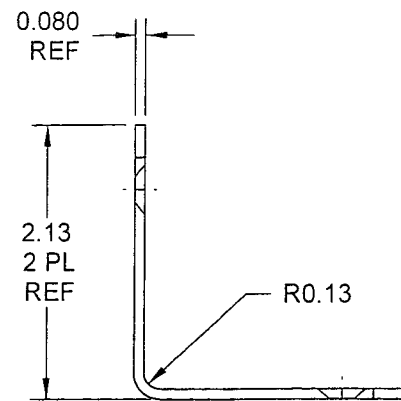
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

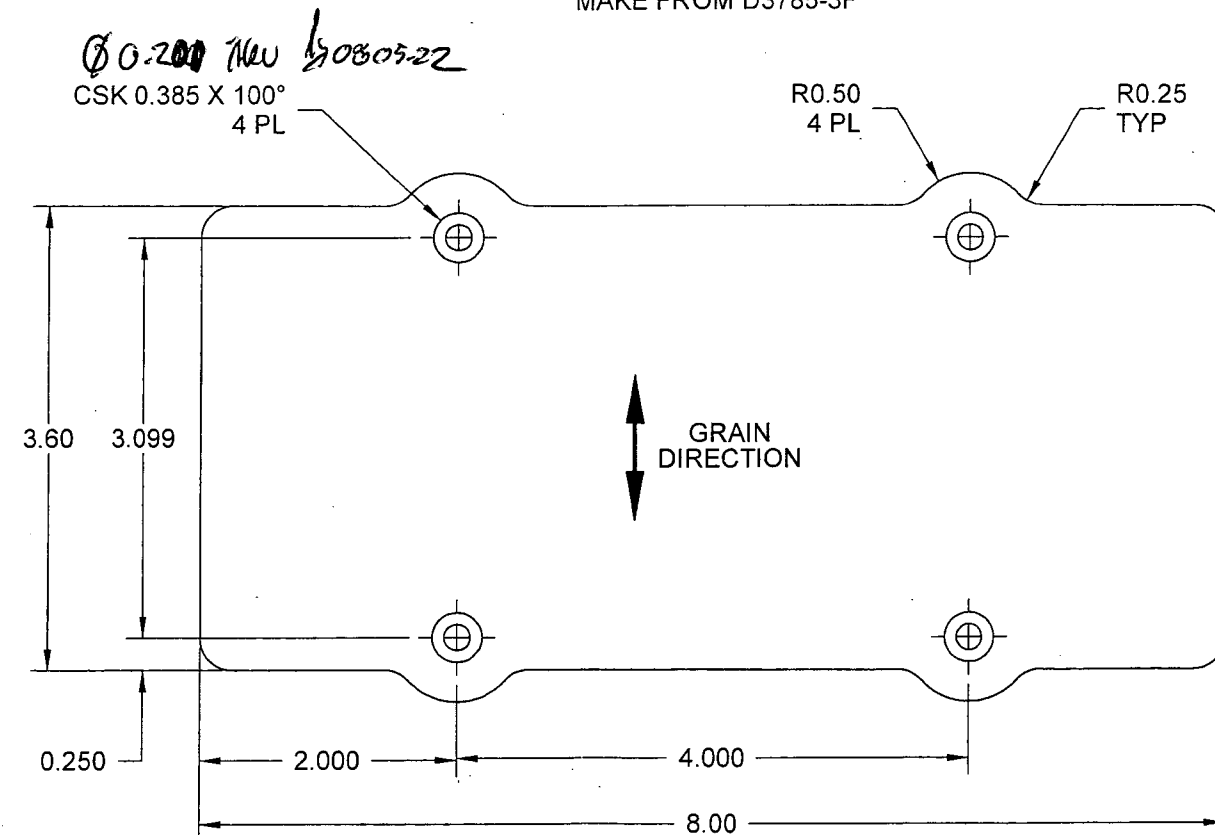
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3785-3 BRACKET
MAKE FROM D3785-3F



D3785-3F FLAT PATTERN BRACKET

D3785-3 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.23 lbs

PROTOTYPE
PRELIMINARY ISSUE
1508-05-21

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3785	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		ARMREST WELDMENT	NTS
DATE	08.04.29	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D412-761

Job #: 00224A

Date: 08.04.30

Product Name: FULL VERTICAL REFERENCE DOOR

Requested By: [Signature]

Design Manager Approval: [Signature]

Quantity	Part Number	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
5	D3701-1F	FLOOR DOUBLER	08.04.30	Y	08.05.02	FOR TESTING	
5	D3702-1	FORWARD DOUBLER	08.04.30	Y	08.05.02	FOR TESTING	
5	D3703-1F	AFT DOUBLER	08.04.30	Y	08.05.02	FOR TESTING	
5	D3703-3F	AFT CORNER DOUBLER	08.04.30	Y	08.05.02	FOR TESTING	
5	D3703-5	AFT CAP	08.04.30	Y	08.05.02	FOR TESTING	
1	D3785-041	ARMREST WELDMENT	08.04.29	N/A	08.05.12	FOR TESTING	
2	D3785-1	TUBE	08.04.29	Y	WEEK OF 08.05.05	FOR TESTING	
2	D3785-3	BRACKET	08.04.29	Y	WEEK OF 08.05.05	FOR TESTING	
2	D3785-5	FIXTURE	08.04.29	Y	WEEK OF 08.05.05	FOR TESTING	

PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D412-761

Job #: 00224A

Date: 08.04.30

Product Name: FULL VERTICAL REFERENCE DOOR

Requested By: [Signature]

Design Manager Approval: [Signature]

Quantity	Part Number	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
1	D3781-041	CUSHION ASSEMBLY	08.04.29	N/A	08.05.12	FOR TESTING	
2	D3781-1	SUPPORTING PLATE	08.04.29	Y	WEEK OF 08.05.05	FOR TESTING	
1	D3781-3	CUSHION	08.04.29	N	END OF MAY	GET QUOTE FROM CHESTNUT RIDGE DAN STOW WILL MAKE ONE FOR TESTS	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 05/05/2008 11:11:52 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET
Job Number : 39033
Estimate Number : 13292
P.O. Number :
This Issue : 05/05/2008 S.O. No. :
Prsht Rev. : NC Part Number : D37853
First Issue : / / Type : R & D SM/MED FAB Drawing Number : D3785 PRELIM
Previous Run : Material :
Written By : Due Date : 08/05/2008 Qty: 3 Um: Each
Checked & Approved By :
Comment : Est Rev:A 08-05-01 new issue DD. verified by:EC

Additional Product

FOR ENGINEERING USE ONLY

~~PRELIMINARY ISSUE~~

Job Number:



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Comment: Qty.: 0.2356 sf(s)/Unit Total: 0.2356 sf(s)

304/316 .125 Sheet

Batch: 104934

6061-T6 0.80" Sheet

8-5-5

IB 8-5-22

107904

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3785

Dwg Rev: PRE-L

Prog Rev: PRE-L

IB 8-5-5

IB 8-5-22

(2)

2- Deburr if necessary

IB 8-5-5

IB 8-5-22

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 8-5-5

IB 8-5-22

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

IB 08/05/05 (K2)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3785

IB 08/05/13 (2)

Receiving Report

Date: 8/5/2
Supplier: CANAL

Batch No: M107904
Dart P/O: 6191

Packing Slip: Yes ☒ No ☐
Invoice: Yes ☐ No ☒
Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐
Waybill Attached: Yes ☐ No ☒
Shipment Complete: Yes ☒ No ☐
QC6 Inspection: 20205106
Work Order: 15

Discrepancies	Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
	M6061T636700X02		12	20	0	8	

Initials of receiver (if shipment OK) Level 12 [Signature]

Location

Production/Admin: 08105106
Date: 20081118
Received/Costing: 08
Initial:

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

7-4248 MONTREAL : 514 336-4248
7-5696 FAX : 514 336-4246

DISTRIBUTEUR D'ACIER ET METAUX SPECIALISES
STEEL AND SPECIALTY METALS DISTRIBUTOR

ONTARIO : 1 800 667-4248
FAX : 1 866 456-4242

On a du Savoir " FER "

SHIP TO:

PAGE LTD
EEN STREET

FACTURE
INVOICE N° 188898

DATE 02/05/08

BON DE LIVRAISON
PACKING SLIP N° 134253

DATE DE LIVRAISON
DELIVERY DATE 02/05/08

TERMES / TERMS	TERR.	REMARQUES / REMARKS	PAGE N°
NET 30 JOURS	2R		001

DESCRIPTION	POIDS WEIGHT	PRIX PRICE	PAR PER *	MONTANT AMOUNT
3/4	36	365.000	CLB	133.16
080 X 144"	192	5.950		1142.40
3/4	4	350.000	CLB	15.47
HARGE	1	3.950	UN	3.95
POIDS TOTAL TOTAL WEIGHT		233		

Formplus N° 861

ALLS REMAIN THE PROPERTY OF "ACIER CAMPI INC." UNTIL PAYMENT IS MADE IN FULL, COMPLETE AND CASHED.
• BUYER'S EXPENSE. • ALL MATERIALS BEAR THE SAME WARRANTY AS GIVEN BY THE MANUFACTURER.
• RESPECT THE FOLLOWING CONDITIONS: NET 30 DAYS FROM BILLING DATE AND THE BUYER ACCEPTS TO PAY
PER MONTH OR 24% PER ANNUM ON ALL PAST DUE ACCOUNTS OVER 30 DAYS. • ANY DEFAULT IN RESPECT WITH
PAYMENT BY ACCELERATION AND PERMITS TO THE SELLER, AT HIS CHOICE TO CLAIM FOR THE BALANCE DUE OR THE
JLD. • ANY CLAIM MUST BE MADE WITHIN FIVE DAYS WITH THIS DOCUMENT ENCLOSED. • ANY MERCHANDISE
OR MODIFIED CANNOT BE RETURNED. • ALL GOODS RETURNED MUST BE WITH OUR AUTHORIZATION AND ARE
HARGE.

N BONNE CONDITION MERCHANDISE RECEIVED IN GOOD CONDITION

A/Y M/M J/D

SOUS-TOTAL 1294.98
SUB TOTAL

T.P.S. 64.75
G.S.T.

T.V.Q. 0.00
Q.S.T.

TOTAL 1359.73

CLIENT / CUSTOMER'S SIGNATURE

DATE

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on this face of this sheet.

Mark J. Vrabec

Mark J. Vrabec
Director of Manufacturing Davenport Works

Kenton P. Young

Kenton P. Young
Quality Assurance Manager

875767
Ship Date 0 B.L. No. Invoice No. Alcoa No. Item
2008-01-16 2726230 00000 4977123-3
P.O. No./Govt Contract No. Customer Mfg Order
N20523

Page 1

Ship To:

Item Description
0.08-IN-TK (+0 -.0045) X 48.0 IN W (+.046875 -.046875) (N) A/T 6061-7
T6 COIL SHEET FOR DISTRIBUTORS TOLERANCE GUARANTEED AMS-QQ-A-250/11
AMS4027 REV M IS 2007 ASTM B209
REV 07 CMMPO19 REV D CMMPO25 REV Q CSTI008 REV
D ((NOT MARKED)) LIGHTLY OILED COIL SIZES:
ID 20 IN COIL NGTS: MAX 5750 LB MAX GROSS
SKID WGT: 6000 LB QUAN TOL +/-30 %
CQR 0211084 REV 02 CUST REQ 08-01-19 *** W/E 08-01-26 ***

Num	Package Ticket	Lot	Weight	Quantity	COM	Pc Id/Serl
1	603377	493536	4363	1	PC	:
2	603424	493536	4391	1	PC	:
			8754	2		

Notes for CQR: 0211084.2

PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/11 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/11F. PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/11 F ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/11.

Exception to Spec CMMPO19 ; Revasn: D Issue: Letter dated 2006-09-28 from AHERN, DENNIS T to BLACKIE, BILL .

Exception to Spec CMMPO25 ; Revasn: Q Issue: Letter dated 2004-08-24 from STEGEMANN, JEAN to BLACKIE, B. .

Exception to Spec CSTI008 ; Revasn: D Issue: Letter dated 2006-12-04 from AHERN, DENNIS T to BLACKIE, BILL .

CQR: 0211084.2 -Specification Limits

Temp	Dir	UTS	TYS	ELAD
		KSI	KSI	PCT
T6	Long Transv.	Max		
		Min	42.0	35.0
				10

Chemical Composition	SI	FE	CU	MN	MG	CR	ZN	TI	Other	Other
									Each	Total Aluminum
Alloy 6061	Max	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.05
Lot: 493536	Min	0.40		0.15		0.8	0.04			REMAIN

- Mechanical, Physical, Metallography, Quantometer Results

Temp	Dir	Test	UTS	TYS	ELAD
			KSI	KSI	PCT
T6	Long Transv.	2	50.2	45.3	11
			50.6	45.3	11.4

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

Mark J. Vrabec

Mark J. Vrabec
Director of Manufacturing Davenport Works

Kenton P. Young

Kenton P. Young
Quality Assurance Manager

876767	0		
<u>Ship Date</u>	<u>B.L. No.</u>	<u>Invoice No.</u>	<u>Alcoa No. Item</u>
2008-01-16	2726230	00000	4977123-3
<u>P.O. No./Govt Contract No.</u>	<u>Customer</u>	<u>Mfg Order</u>	
N20523	SAMUEL SON & CO LT DCE-77123-3		

Ship From: RIVERDALE, IA.

Page 2

Lot: 493536 - Mechanical, Physical, Metallography, Quantometer Results (cont.) -----
 Cast Number Chemical SI PE CU MN MG CR ZN TI
 H313506A Actuals 0.62 0.4 0.25 0.06 1.0 0.19 0.03 0.02

This material was melted in the United States or a Qualifying Country [REF DPARS 225.872.1(a)]; it was manufactured in the United States